

# Work Order ID 82368

March-29-12 3:09:30 PM

**\*82368\***

Page 1

Item ID: D2574

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, Aft In 205

Stop **\*NS2\***

Start Date: 3/29/12 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 82368 Double check by: 11 1-Machine Step  
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine  
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-  
Machine Step No 3 per Folio FA051 and insp

*off/BG*  
12/04/09  
B.A 12/04/12

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

*off/BG*  
12/04/09  
B.A 12/04/12

120

0.00

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*off/BG*  
12/04/09  
B.A 12/04/12

# Work Order ID 82368

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**\*82368\***

Page 2

Item ID: D2574

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Saddle, Aft In 205

Stop

**\*NS2\***

Start Date: 3/29/12

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/06/12

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

345

M 12134

12 12-4-16

12x 12/04/16

**Work Order ID 82368****\*82368\***

Page 3

March-29-12 3:09:30 PM

Item ID: D2574

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, Aft In 205

Start Date: 3/29/12 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12 12 4-16

170

Identify as per dwg & Stock Location: SI 433 0.00**\*170\***

Packaging

Memo

0.00

Packaging

12x

SP 12-4-17

180

QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/4/17  
ME  
12-4-17

# Picklist Print

March-29-12 3:09:29 PM

Page 1

Work Order ID: 82368

Parent Item: D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 3/29/12

Required Date: 4/06/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 Saddle Billet		Manufactured	No			110	Each	33.0000	1	12			

## Location

## Loc Qty

## Loc Code

MAT041

4

76838

4

MAT044

28

79874

28

MAT045

1

74507

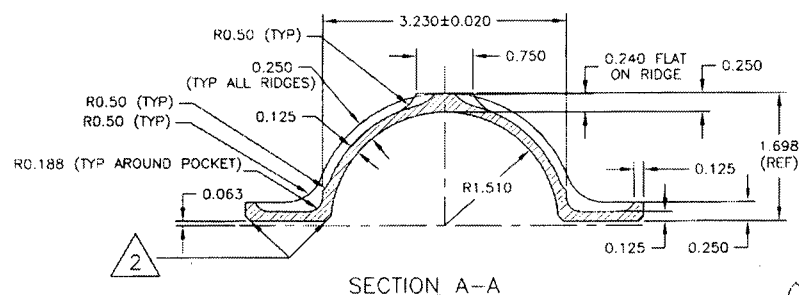
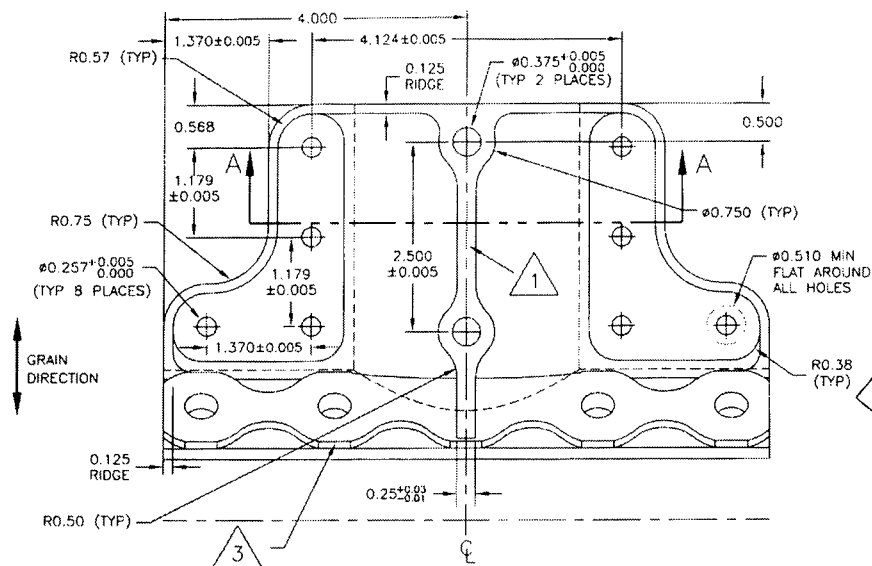
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81973

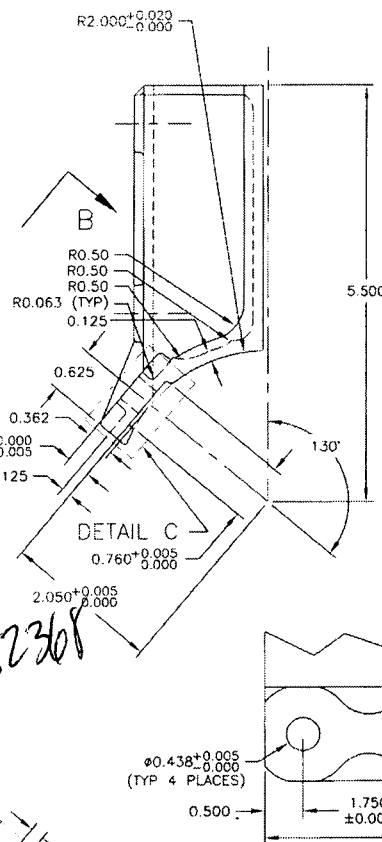
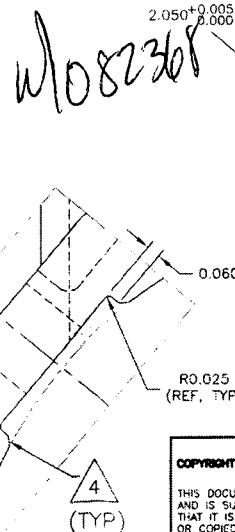
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12104109

RELEASED  
02-06-11



DETAIL C  
SCALE 2:1

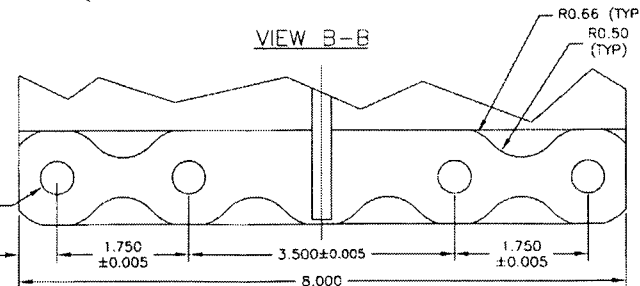


# NOTES

MATERIAL: 7075-T7351 (00-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:1

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DART AEROSPACE LTD.

**DART**

DART AEROSPACE LTD.  
HAINESBURY, ONTARIO, CANADA

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <i>5236</i>
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	<del>438</del>	.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.503	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.503	.501	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.569	.565	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.128	.126	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.249	.249		
S	0.115	0.135		.128	.128	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.237	.238		
W	0.115	0.135		.135	.135	.135	.130		
X	0.307	0.312		.310	.310	.309	.308		
Y	0.760	0.765		.761	.761	.760	.760		
Z	0.352	0.372		.368	.368	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.623	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.252	.246	.246		
AE	1.500	1.520		1.512	1.512	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.242	.242	.247	.247		
AI	2.000	2.020		2.004	2.004	2.005	2.004		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	<i>SC</i>
Date:	12/04/08

Audited by:	<i>JL</i>
Date:	12-04-15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>8345</i>
<b>Description:</b> Saddle, Aft Inboard		<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.497	.499	.499	.500		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.567	.566	.567	.567		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.248	.249	.250		
S	0.115	0.135		.130	.130	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.238	.239	.238	.240		
W	0.115	0.135		.128	.129	.129	.127		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.622	.623	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.245	.247	.247		
AE	1.500	1.520		1.5105	1.510	1.511	1.5115		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.247	.248	.247	.248		
AI	2.000	2.020		2.003	2.003	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>ent</i>
Date:	12/04/10

Audited by:	<i>J</i>
Date:	12-04-15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>57345</i>
<b>Description:</b> Saddle, Aft Inboard		<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1/1	2/10	2/11	4/2		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.499	0.498	0.499		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.499	.499	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	0.249		
S	0.115	0.135		.130	.129	.131	0.131		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.238	.239	.238	0.238		
W	0.115	0.135		.129	0.128	0.129	0.128		
X	0.307	0.312		.309	0.309	0.309	0.309		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		.364	0.364	0.363	0.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	0.623	0.623	0.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	0.247		
AE	1.500	1.520		1.511	1.511	1.515	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	0.275		
AH	0.240	0.260		.248	.248	.247	0.247		
AI	2.000	2.020		2.003	2.003	2.003	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SL</i>	Audited by: <i>SL</i>
Date: <i>12/04/10</i> / <i>12/04/12</i>	Date: <i>12-04-15</i>

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A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



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